<b>Work Orde</b> <i>May-28-13</i> 10:1					*102	453*					· · · · · · · · · · · · · · · · · · ·	Page 1
Item ID: Revision ID:	D4057-	1			Accept	*N900	040	100	)* s	Setup Sta	rt <b>*N</b>	S1*
Item Name:	Retainin	g Ring								Sto	<sup>p</sup> *N	S2*
Start Date: Required Date: Reference:	5/22/13 5/27/13	Start Qt Req'd Q	-	*8* *8*		Cust Item I Customer:	D:					. *
Approvals:	Proces	s Plan: ML	<b>3</b>	Date: 13-05-29	7 Tooling:	D:	ate:		F	Run Sta	I/I	R1*
	QC: _			Date:	•	D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operatio Descripti		· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr										
D4057		A							. Cl			
100					0.00				1 Co			
*100* Purchasing				<b>R6 26024</b> art as per Dwg D4057  00-75	0.00		•	m	<u> </u>	123		· ·
			Possible Su Material re	ipplier: Spaenaur lease note required	<b>∽</b>						1	

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\* Packaging

Packaging

Memo

0.00

10/3/6/4 8

DQA:		_ Date:										<b>™</b> ⊃∧ DT
					WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE			_	_ AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS	
Work Orac					Rework	]		Skid-tube Cross	stube	1	Water Jet	Engineering
Part N	lo.				Scrap			<b></b>	ıll Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	moforming Fini	ishing	4	re/Packaging	Other
NCR N	۱٥.	<u> </u>			Suspected Unapproved			Large Fab Comp	posite	]	Supplier	
Root				Desc	ription of work order update		nitial	Action		Sign &		1
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material							. : * .	<b>1</b>				
Operator							\ \					
Offset/Setup						İ						
Process												,
Supplier												
Training												
Transport	_											
Unapproved												
		•	1849			FAI	JLT CAT	TEGORY				
Landir F	ng Gear			· · · ·	General	_	1		·	7		¬
	Bending			<u> </u>	Bend	<u> </u>	1	Program		Outside Dim	· · · -	Pressure/Forced
}		lot Concer	ntric		BOM/Route	<u> </u>	Grain		ļ	Over/Under	<u> </u>	Set-up
1	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred		Temperature/Cure
		ink/Ripple	:/Wave	-	Burrs	<u> </u>		ion Incomplete/Unqualified	d	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		l .	ions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
	Crushing			ļ	Countersink	<u> </u>		ned/off center	<u> </u>	Positioned V		7
-	Heat Tre		<b>-</b> .		Cut Too Short	<u> </u>	Mislabe		<u> </u>	Power Loss/	Surge	Other
}		on Strip in	Tube	<u> </u>	Drawing	$\vdash$	Misread	t			<u> </u>	
-	Marks/C			-	Drill Holes	_	Off-set	- 111		<del></del>	-	
ŀ		Sequence		-	Finish Fit/Function	$\vdash$		Calibration				
	I VV AVE/ I V	wish in till	1111		(F)(/F)(f)(f)(f)(f)		11 1111 01 5	AGUANCA				

Work Orde		2453		*102	453*				·		Page
Item ID: Revision ID:	D4057-1			Accept	*N900	<b>040</b>	100	<b>)*</b> Setup Star		*NS1	
Item Name:	Retaining Rir	ng							Sto	• *N	S2*
Start Date:	5/22/13	Start Qty: 8.00	*8*		Cust Item I	D:					
Required Date:	5/27/13	Req'd Qty: 8.00	*8*		Customer:						
Reference:			.,								
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	_	R	kun Sta	17	R1*
•	QC:	,	Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC6- Inspect dimensions	s to drawing	0.00				C			
*120*				27				8		- <del> </del>	
QC Quality Control		Memo		0.00	.4						

130

Identify as per dwg & Stock Location:

\*130\*

Packaging Packaging

Memo

0.00

Page 2

140

QC21- Final Inspection - Work Order Release 0.00

\*140\*

Memo

0.00

Quality Control

MCD 13-06-05

DQA:		_ Date:				_	<b></b>					<b>™</b> ∂ΔRT
QA Closed:		Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / U		Vork Order u	odate only	A E R O S P A & E
				·	DISPOSITION							
Work Ord	er:										·	<del>-</del>
D	Part No.				Rework			Skid-tube Crosstube		-	Water Jet	Engineering
Parti	Part No.				Scrap		1	Machining	Small Fab	-	d. Eng. Coor.	Quality
NCD !	Ma				Use-as-is Suspected Unapproved		Inerr	noforming	Finishing	Hec/Sto	re/Packaging	Other
NCR 1	NO				Suspected Onapproved	l		Large Fab	Composite _		Supplier	
Root			· ·	Desc	ription of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC inspector
Design												
Doc/Data											; 	
Equip/Tooling												
Handling/Pre		:						}				
Material												
Operator			l									
Offset/Setup												
Process												
Supplier												
Training												
Transport									•			
Unapproved												
						FAI	ULT CAT	regory				
Landi	ng Gear			_	General				-			<u> </u>
	Bending				Bend		1	rogram	_	Outside Dim	ensions	Pressure/Forced
	<b>—</b>	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure
	<b>—</b>	(ink/Ripple	/Wave	<u> </u>	Burrs		Inspecti	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
	Cuffs			_	Contamination		Instruct	ions Incomplete/l	Jnclear	Part Moved		Wrong Stock Pulled
	- Crushin	_			Countersink		1	ned/off center	L	Positioned V	Vrong	_
	Heat Tr				Cut Too Short		Mislabe	led	L	Power Loss/	Surge	Other
	<b>—</b>	on Strip in	Tube		Drawing		Misread	1				
	Marks/0				Drill Holes		Off-set					
	<b>-</b>	Sequence			Finish		Out of 0	Calibration				
	Wave/T	wist in Tub	oe		Fit/Function		Out of S	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

May-28-13 10:13:46 AM

Work Order ID:

102453

Parent Item:

D4057-1

Parent Item Name:

Retaining Ring

**Start Date: 5/22/13** 

Required Date: 5/27/13

Start Qty: 8.00

Required Qty: 8.00

. Comments:

IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev B 10.05 17 as per ECN10-562 DD verf EC

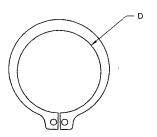
	IPP Rev:B 10.05.1	as per ECN10-	302 DD	veri.eC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
R3100-75		Purchased	No			110	Each	0.0000	1	8			
Retaining Ring											· <u></u>		

DQA:		_ Date:										™ A DT
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDA		/ork Order u	ndate only   [	AEROSPACE
Q/Y Closed.		oute.					I	_			· · · · · · · · · · · · · · · · · · ·	
Work Orde	er:			5	DISPOSITION			A	GAINST D	EPARTMENT	/PROCESS	
					Rework	]		Skid-tube Crosstube			Water Jet	Engineering
Part N	lo				Scrap			Machining Sn	nall Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	]	Therr	moforming Fi	inishing	Rec/Sto	re/Packaging	Other
NCR N	lo			_	Suspected Unapproved	}		Large Fab Con	mposite		Supplier	
Root				Descr	ription of work order update		Initial	Action	· · ·	Sign &		
Cause	Date	Step	Qty	_	or non-conformance	Cr	nief Eng	Description	า	Date	Verification	QC Inspector
Design		T .										
Doc/Data			1 1									
Equip/Tooling												
Handling/Pre												
Material												
Operator			]									
Offset/Setup												
Process	_					1						
Supplier	_											
Training	_										·	
Transport											a.	
Unapproved		<u> </u>			-							
						FA	ULT CA	TEGORY				
Landir	ng Gear				General		7 /-		_	٦		<del>_</del>
	Bending		_ *		Bend BOM (Bourte		-	Program	-	Outside Dim	<del> </del>	Pressure/Forced
}		lot Concer	ntric	_ ⊢	BOM/Route	-	Grain		<u> </u>	Over/Under	<del>-</del>	Set-up
	Cracks	nt /Dinnlo	//4/2002	$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorred	<u> </u>	Temperature/Cure
	Cuffs	nk/Ripple	y wave		Burrs	$\vdash$	1	ion Incomplete/Unqualif	<u></u> ⊢	Part Lost/Mi	ssing	Weld
	Crushing	•			Contamination Countersink	$\vdash$	4	cions Incomplete/Unclear	<sup>r</sup> ⊢	Part Moved	L	Wrong Stock Pulled
	Heat Tre				Cut Too Short	$\vdash$	Mislabe	gned/off center	-	Positioned V	_	Jothan
		ar on Strip in	Tubo	$\vdash$	Drawing	$\vdash$	Misread			Power Loss/	Surge	Other
ŀ	Marks/C		TUDE	$\vdash$	Drill Holes	-	Off-set					·
		Sequence			Finish	$\vdash$	-	Calibration			· ·	
		vist in Tub			Fit/Function	<b>—</b>	4	Seguence		<del></del>		

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

### **SPECIFICATION CONTROL DRAWING**





Sept. 2. 4 NG450 1 27 1 3 LACONT, LEGICOPY RELIGIONATION IN NOVIENT V .... W.K. DILER MCJ 13-05-29

DART P/N	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	FREE DIAMETER	THICKNESS	FITS GROOVE WIDTH	COATING
D4057-1	SPAENAUR	R3100-75	0.693	0.042	0.046	NONE
D4037-1	MAIN INDUSTRIAL	0-5100075	0.693	0.042	0.046	NONE



#### **D4057-X RETAINING RING**

NOTES: 1) MATERIAL: SEE TABLE

1) MATERIAL: SEE TABLE
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY CONTAINER WITH DART P/N "D4057-X" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: N/A

Α NEW ISSUE 10.02.05 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A MFG. APPR D4057 SHEET 1 OF 1 APPROVED TITLE SCALE **RETAINING RING** DE APPR. ŅTS DATE 10.02.05 COPYRIGHT © 2010 BY DART AEROSPACE LTD
THE DOCUMENT IS PRIVATE AND COMPONITION, AND IS SUPPLED ON THE EXPRESS CONDITION OF THE PERSON OF THE P



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

# **PURCHASE ORDER**

# Purchase Order ID PO20024

Purchase Order Date 5/29/2013 PO Print Date 6/3/2013

Page Number 1 of 2

REDISE

Order From:

VC-MAI001

MAIN INDUSTRIAL SALES LTD. 1475, TESSIER HAWKESBURY, ON K6A 3S6

CA

Contact Name

Vendor Phone

613 632 3595

Vendor Fax

613 632 0262

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms Currency Net 30

**FOB** 

CAD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

Line Nb	r Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
i 6:	58-065	Washer	6/5/2013 Yes	100.00 Each	Dart Truck	\$0.2930	\$29.30
2 R3	3100-75	Special Inst:	MANUFACTUF D3904 REV B BATCH 102405 6/5/2013 Yes	RE AS PER DRAW 8.00 Each	ING  Dart Truck	\$0.2532	\$2.03
		Special Inst:	D4057 REV A BATCH 102453			ege	
680	90ZZ	Bearing	MAIN INDUSTR 6/5/2013 Yes	PIAL P/N 0-510007: 100.00 Each	5 Dart Truck	\$1.4800	\$148.00

Special insa-

MANUFACTURE AS PER DRAWING

D3183 REVC1 BATCH 102531

No substitution or deviation without consent.

Certificate of Conformity or Material-Certification required / KES

Change Nbr:

Change Date: 6/3/2013

# MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.

HAWKESBURY ON K6A 3S6

Phone: (613) 632-3595 Ext. Fax: (613) 632-0262

sales@mainindustrialsales.com

Packing Slip

DATE June 03, 2013

NUMBER 0000163145

CUSTOMER NO. DART

#### BILL TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7

#### SHIP TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7

(613) 632-5200 Ext.

(613) 632-5200 Ext.

P.O. NUMBER	SALESPERSON	ORDER (	DATE	REQ. DA	re ord	ER NUMBER				
20024	EB	03-Jun-	03-Jun-13			000163145				
F.O.B.	SHIP VIA			TERMS						
F.O.B. value	OUR TRUCK / LOÇAL			NE.	T 30 DAYS					
PART NUMBER					QUANTITY					
DESCRIPTION	LOCATION	UC	M	REQ.	SHIPPED	B.O.				
0-658065 .203 x .875 x .040075 FLAT WASHER ZI	NC	EA	Tr. es es	100	," ,	100				
YOUR-PART #: 658-065 0-5100075 5100-075 RETAINING RING	7D5	EA		8	8					
YOUR PART # R3100-75 0-68002ZKML BALL BEARING	6D6	EA		100	100					
YOUR PART #: 6800ZZ 0-69002ZKML KML BALL BEARING	6D6	EA		100	100					
YOUR PART #: 6900ZZ										